

304 .375

Work Order ID 86937

86937

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July-09-12 2:51:55 PM

Item ID: D2327-3 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Spacer Bushing
 Start Date: 7/09/12 Start Qty: 30.00 *30* Cust Item ID:
 Required Date: 8/10/12 Req'd Qty: 30.00 *30* Customer:
 Reference:

Approvals: Process Plan: MLJ Date: 12/07/10 Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D2327	Rev D

100

0.00

100

Hardinge CNC LATHE SMALL

Hardinge

Memo

0.00

Hardinge CNC Lathe Small

Turn per Folio FA232 and Dwg D2327 Deburr

ML 12/09/14

30

110

0.00

110

QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

ML 12/09/14

30

120

0.00

120

QC8- Inspect parts - second check

QC

Memo

0.00

Quality Control

SL 12-9-17

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 86937

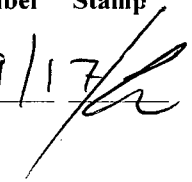
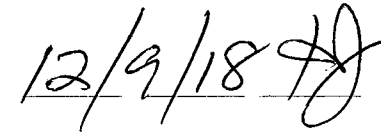
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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 *130* Packaging Packaging	Identify as per dwg & Stock Location: <u>WA</u> Memo *****STOCK IN BASKET CELL*****	0.00 0.00				30	8	12/9/17	
140 *140* QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00						12/9/18	

12-09-17

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

Picklist Print

July-09-12 2:51:55 PM

Work Order ID: 86937

Parent Item: D2327-3

Start Date: 7/09/12

Required Date: 8/10/12

Parent Item Name: Spacer Bushing

Start Qty: 30.00

Required Qty: 30.00

Comments: IPP F05.11.02Removed 303 SSKJ/EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304R0.375 304 ROUND BAR 0.375		Purchased	No			100	f	57.0920	0.1563	4.935789			

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
MAT029	57.092	
119346	1.564	
120204	2.721	
121380	4.807	
→ 121728	48	

4.94 on 12/09/12

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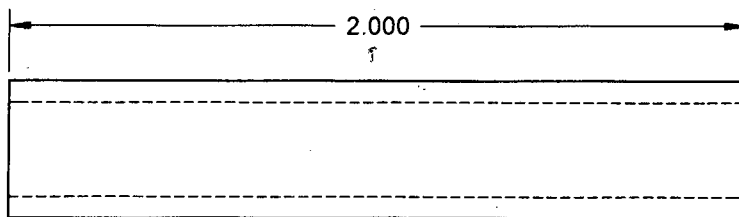
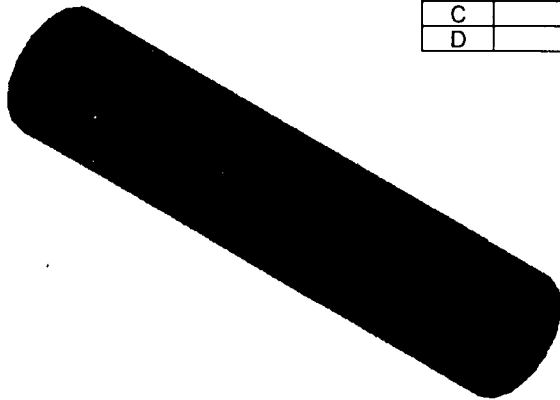
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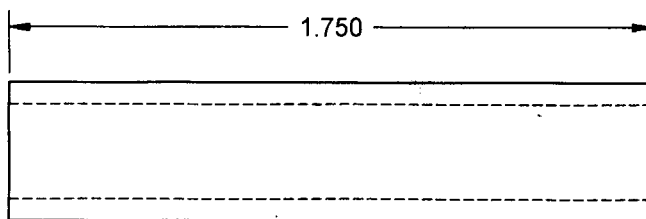
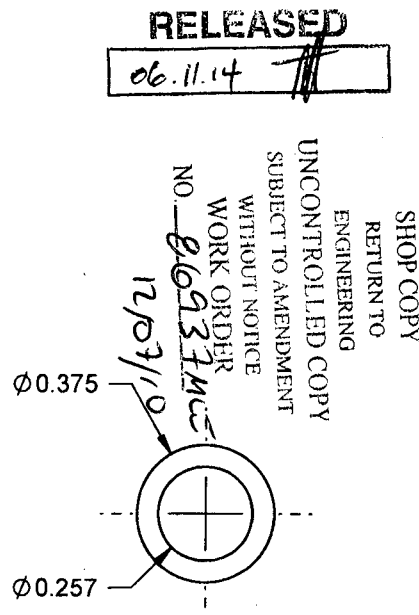
NOTE: Date & initial all entries



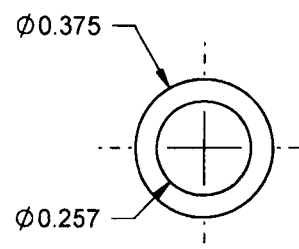
DESIGN BW	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED LE	APPROVED H	DRAWING NO. D2327	REV. D SHEET 1 OF 1
DATE 06.10.12		TITLE SPACER BUSHING	SCALE 2:1
REV	DATE	DESCRIPTION	
A	94.12.17	NEW ISSUE	
B	95.12.06	LENGTH CHANGE	
C	03.05.13	303 SS SPEC ADDED	
D	06.10.12	REMOVE 303 SS MATERIAL	



D2327-1 SPACER BUSHING



D2327-3 SPACER BUSHING



NOTES:

- 1) MATERIAL: AISI 304/316 SS, Ø0.375, 0.065 WALL SEAMLESS ROUND TUBING (REF. DART SPEC M304TR0.375W.065)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP CORNERS TO 0.010 MAX



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Dart Aerospace Ltd

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